

Work Order ID 154785

Wednesday, December 21, 2016 11:55:05 A

154785

Page 1

Item ID: D2877 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle Spacer
Start Date: 12/19/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 12/21/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: **DEC 21 2016** Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2877	Rev B								

100

0.01

100

FLOW WATER JET

Waterjet

Memo

0.04

FLOW CNC Waterjet

1-Cut as per Dwg D2877 Dwg Rev: B Prog Rev: B 2-
deburr

(16)

dc 17/01/05

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.02

Quality Control

(16)

dc 17/01/05

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.04

Quality Control

(16) 17-01-06

DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

154785

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N900040100

Setup Start *NS1*

Stop *NS2*

12

Cust Item ID:

Start Date: 12/19/2016 **Start Qty:** 12.00

Required Date: 12/21/2016 **Req'd Qty:** 12.00

12

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.02							
Hand Finishing									2017/01/09 BEB
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.02							
Quality Control									DAS 38 9-89 JAN 10 2017
160	Identify as per dwg & Stock Location: <u>STQSA</u>	0.00							
160									
Packaging	Memo	0.02							
Packaging									DAS 6 9-89 JAN 10 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Revision ID: Stop ***NS2***
Item Name: Saddle Spacer
Start Date: 12/19/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 12/21/2016 Req'd Qty: 12.00 ***12*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.20							
Quality Control									

DAS
21
9-89

JAN 17 2017

VS 17/1/11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Wednesday, December 21, 2016 11:55:05 AM

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Work Order ID: 154785

154785

Parent Item: D2877

D2877

Parent Item Name: Saddle Spacer

Start Date: 12/19/2016

Required Date: 12/21/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP B 00.05.19 Added inspect level 8 EC
IPP C 06.04.26 Water jet EC
IPP Rev:D Now M6061-T6 06-06-23 JLM
IPP Rev:E Updated Thickness as per Rev B 06-09-18 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			110	sf	59.5000	0.0607	0.766737			

M6061T6S 125

6061-T6 .125 Sheet

ac 17/01/05

Location

Loc Qty

Loc Code

MAT020

59.5

m135860

11.5

m136327

48

0.7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

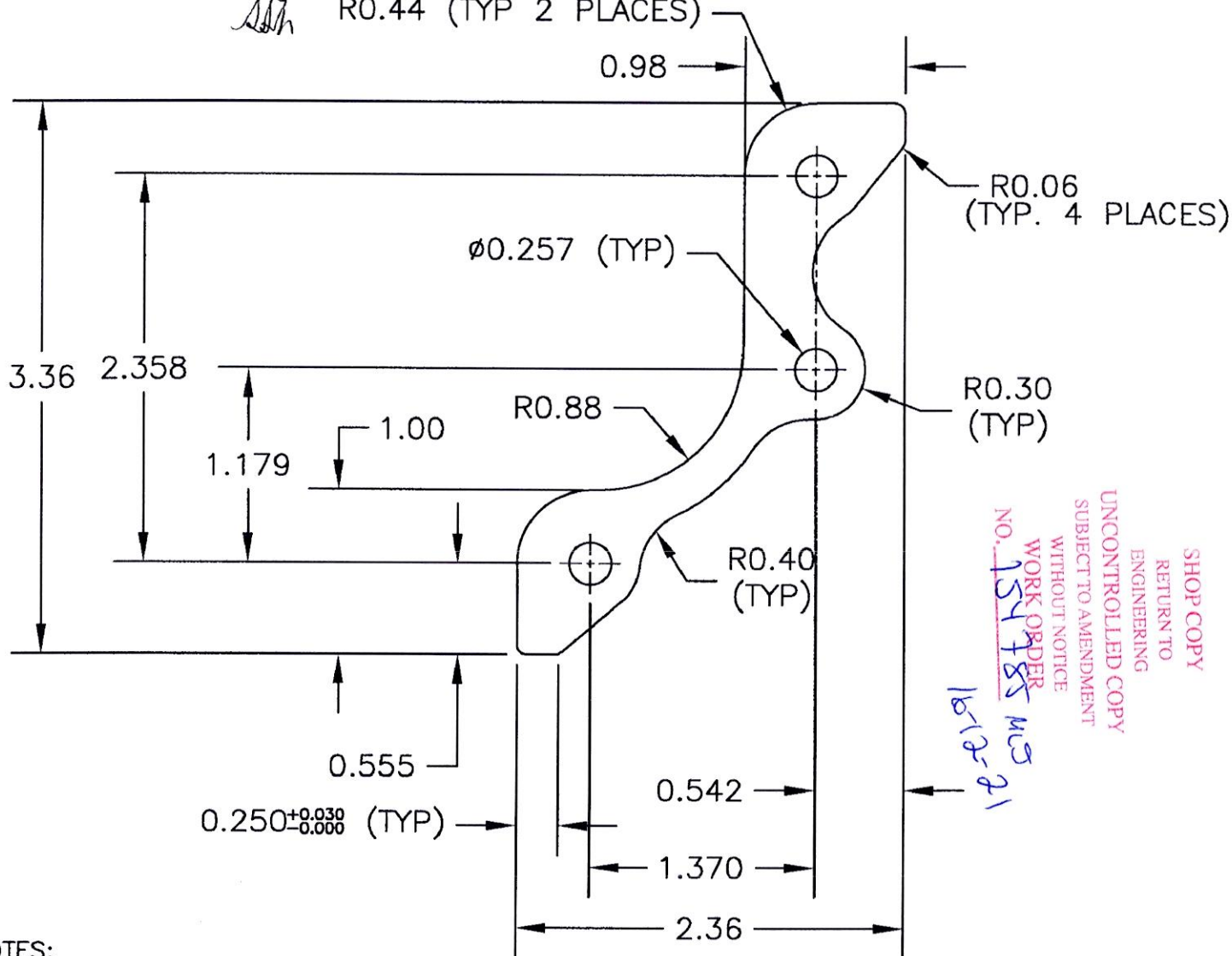
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OTHER :																					

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2877	REV. B SHEET 1 OF 1
DATE 06.05.17		TITLE SADDLE SPACER	SCALE 1:1
A	99.02.23	NEW ISSUE	
B	06.05.17	THICKNESS WAS 0.100", MAT CHANGE	

RELEASED
*06.06.21**AS PER ECN 013*

R0.44 (TYP 2 PLACES)

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.125" THICK
(REF DART SPEC M6061T6S.125)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.125" THICK
(REF DART SPEC M5052H32S.125)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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